

Date: Thursday, 9/14/2006 4:32:43 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, RS, 206
 Job Number : 28604
 Estimate Number : 10821
 P.O. Number : N/A Part Number : D26662
 This Issue : 9/14/2006 S.O. No. : N/A Drawing Number : D2666 REV. C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 28551 Material : N/A
 Due Date : 9/30/2006 Qty: 8 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: C 00.11.01 - Removed P/O for Powder Coat - in house processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: B25344

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on 06.09.19 by SA

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

SA 06.09.19

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 06.09.19

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.09.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/18/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 4:32:43 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 28604

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/09/27

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06-09-28

(8)

7.0

POWDER COATING

POWDER COATING



M.101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

yl

06/10/12 x 8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ml 06/10/13

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: - ST482

ml 06/10/13

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06.10.13

Job Completion



U 06.10.13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 28604
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.123	.122	.123		
B	0.100	0.140		.122	.122	.122	.122		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.222	.222	.222	.222		
F	1.313	1.343		1.319	1.326	1.326	1.326		
G	0.240	0.260		.251	.251	.250	.251		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.134	1.133	1.134	1.134		
J	0.990	1.010		1.001	1.002	1.000	1.000		
K	0.235	0.240		.237	.237	.237	.237		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.110	.111	.110	.112		
N	1.565	1.585	DT8888						
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.256	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.498	.500	.497		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.498	2.498	2.499	2.499		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.549	.548	.550	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD
Date: 06.09.15

Audited by: J.L
Date: 06/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28604
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.123	.123	.122		
B	0.100	0.140		.122	.122	.122	.122		
C	2.470	2.510		2.490	2.490	2.490	2.490		
D	0.100	0.180		.170	.170	.170	.170		
E	0.210	0.230		.222	.222	.223	.221		
F	1.313	1.343		1.326	1.326	1.326	1.326		
G	0.240	0.260		.251	.252	.250	.250		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.134	1.133	1.134	1.133		
J	0.990	1.010		1.001	1.000	1.001	1.000		
K	0.235	0.240		.237	.237	.237	.237		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.112	.111	.111	.112		
N	1.565	1.585	DT 8888						
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.497	.496	.499	.500		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.498	2.499	2.500	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.549	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

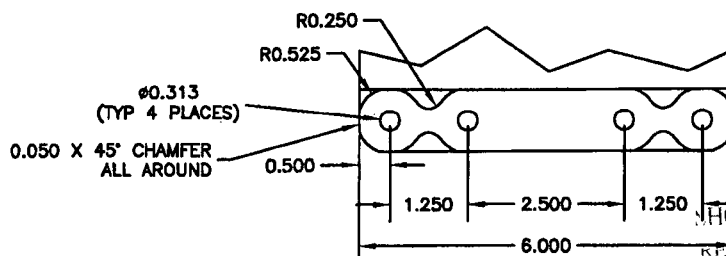
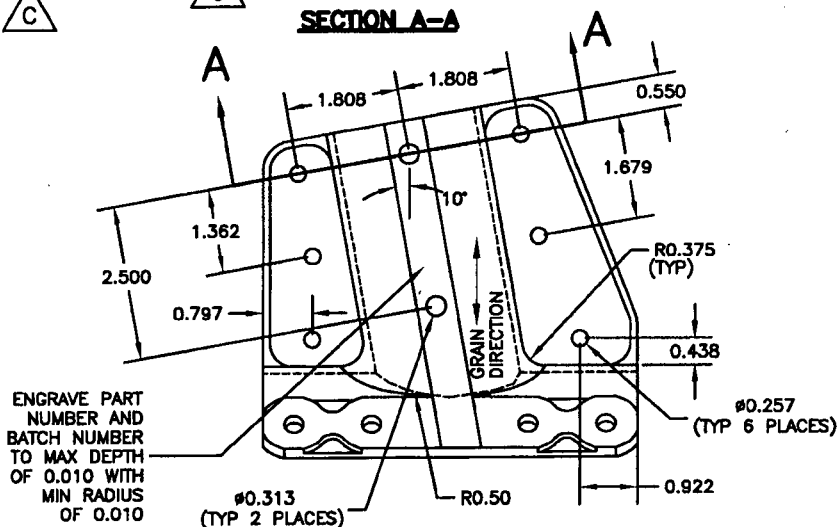
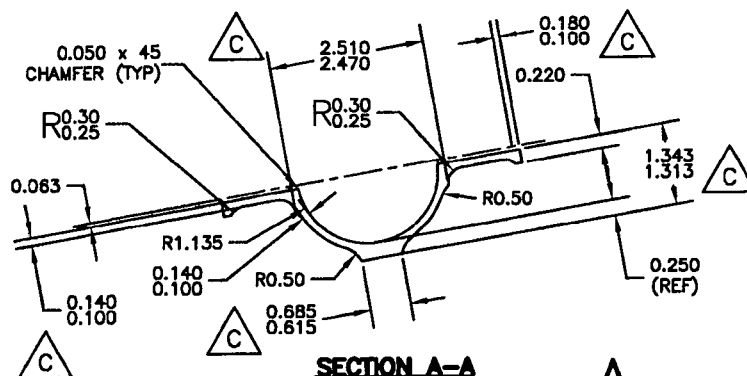
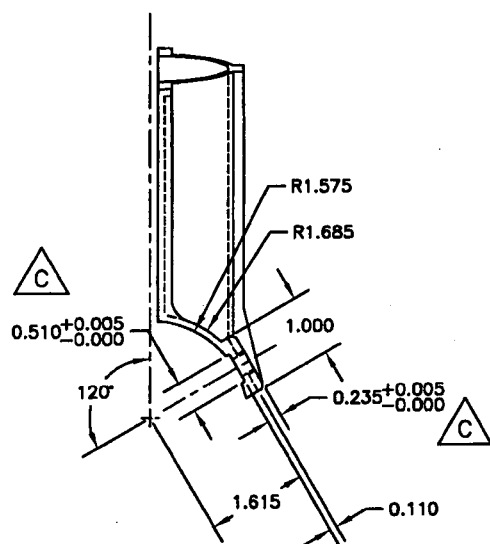
Measured by: S D
Date: 06.09.20

Audited by: J.L
Date: 06/09/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART**RELEASED**
06.05.26

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2666	REV. C SHEET 1 OF 1
DATE 06.05.26		TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	

**D2666-1 SADDLE FWD INSIDE HIGH****NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

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